

Work Order ID 120482

June-18-14 1:24:36 PM

D2724-042

120482

B120482

Page 1

Item ID: D2724-042

Revision ID:

Item Name: 206L Step Ass'Y, RH

Start Date: 6/04/14

Start Qty: 4.00

Required Date: 6/04/14

Req'd Qty: 4.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2724

Rev C

100

0.00

100

Large Fab

Large Fab

Large Fab

Memo

0.00

Cut D2724-2 using D2622 extrusion as per Dwg D2724
Deburr and bevel ends for welding

5

DMC
146-20

110

0.00

110

Large Fab

Large Fab

Large Fab

Memo

0.00

Weld end cap (One End Only) and lugs as per Dwg D2724 using Jig DT8898
followed by Jig

A/R AL ROD Batch:

128385

125091

Grind end cap welds flush

DMC

14-7-16

5

6

14-07-22

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[illegible]

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Setup  Start  *NS1*
          Stop   *NS2*

```

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run	Start	*NR1*
	Stop	*NR2*

150 QC3- Inspect Part Finish

Quality Control

Memo

0.00

0.00

160

Large Fab

Large Fab

Large Fab

Memo

Inspect for foreign object per QSI 024

Weld Remainig end cap as per Dwg D2724

A/R AL ROD Batch: M/28956

Grind end plate flush. DMC 14-07-28

0.00

0.00

170

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

0.00

5 _____ 16
14.07.24

5 JUL 24 2017 DAS
24
9-89

5

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Item ID: D2724-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: 206L Step Ass'Y, RH
 Start Date: 6/04/14 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 6/04/14 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		28 14/07/28		(5)			DAS 9 9-89
190 *190* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				5	7/6/14-7-28		
200 *200* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 9:00 OVEN TEMPERATURE: 320° FINISH TIME: 9:30	0.00 0.00				S			CR 14-07-30

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Item ID: D2724-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: 206L Step Ass'Y, RH
 Start Date: 6/04/14 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 6/04/14 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
210	QC3- Inspect Part Finish	0.00								
210										
QC	Memo	0.00								
Quality Control										
220	Wing Walk as per dwg QSI005 4.4 Batch 11296980	0.00								
220										
HandFinish	Memo	0.00								
Hand Finishing										
230	QC3- Inspect Part Finish	0.00								
230										
QC	Memo	0.00								
Quality Control										

DAS
15
9-89

DAS
16
9-89

14/07/31

SRH f all 14/07/31

Picklist Print

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Work Order ID: 120482

120482

Parent Item: D2724-042

D2724-042

Parent Item Name: 206L Step Ass'Y, RH

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:E As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2734		Manufactured	No			110	Each	123.0000	1	4			
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D2734

Step End Plate

PL 14-7-25

Location	Loc Qty	Loc Code
WA003	123	
119286	86	
<u>119498</u>	36	
99709	1	

5

D2734		Manufactured	No			160	Each	123.0000	1	4			
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D2734

Step End Plate

PL 14-07-10

Location	Loc Qty	Loc Code
WA003	123	
119286	86	
<u>119498</u>	36	
99709	1	

5

D3458-1		Manufactured	No			110	Each	19.0000	2	8			
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D3458-1

Step Mounting Plate

PL 14-07-10

Location	Loc Qty	Loc Code
WA003	19	
<u>119278</u>	18	
96904	1	

10

Picklist Print

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Work Order ID: 120482

120482

Parent Item: D2724-042

D2724-042

Parent Item Name: 206L Step Ass'Y, RH

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 4.00

Required Qty: 4.00

D3458-3

Manufactured No

110 Each

21.0000 2 8

D3458-3

Step Mounting Plate

14.07.10

Location

Loc Qty

Loc Code

WA003

21

119279

21

D2622-120C

Manufactured No

100 Each

91.0000 1 4

D2622-120C

Step Extrusion

DK 146-20

Location

Loc Qty

Loc Code

HALL

32

109575

32

WA003

59

101765

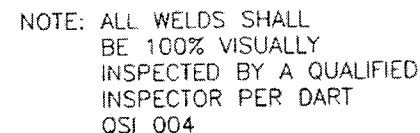
1

115141

58

(5A)

OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DARI AEROSPACE USA, INC.



APPLY BLACK
ANTI-SKID ON
- TOP SURFACE
TO BOTTOM
OF TOP RADIUS

- REFER TO STEP
END DETAIL

D2724-1
MAKE FROM EXTRUSION D2622-107

D2724-041 LH STEP ASSEMBLY (SHOWN)
D2724-042 RH STEP ASSEMBLY (OPPOSITE)

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

WORK ORDER NO. 120482 MJS TYPICAL STEP END DETAIL NOT TO SCALE

D2734 END PLATE

D2724-041/-042 STEP ASSEMBLY

- WORK ORDER TYPICAL S
NO. 120482 MJS NOT
- 1) MAKE FROM EXTRUSION D2622
 - 2) WELD PER DART QSI 004
 - 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 14-06-09
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05.11.14

DART

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED	PH	APPROVED	PH	DRAWING NO.	REV. C
				D2724	SHEET 1 OF 1
DATE				TITLE	SCALE
05.09.19				206L/407 STEP ASSEMBLY	NTS
A		97.12.04		NEW ISSUE	
B		98.10.19		UPDATED WELD DETAIL REVISED TOLERANCES	
C		05.09.19		RE-DESIGN, ADD D3458-1/-3	

